

Work Order ID 127706

127706

Page 1

Item ID: D206-781-151KIV

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop *NS2*

Start Date: 12/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-12-23

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-781	D								
100	Document Control	0.00							
100									
DC									
Doc.Control -USB or Paperwork									
	Memo	0.00							
	Photocopy bluefile & type labels per PPP D206-781-151KIV (CHG 001)								
110	Pick Kit	0.00							
110									
Packaging									
Packaging	Memo	0.00							
120	QC4-100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control	Memo	0.00							

DAS
27
9-89

MCS 15-02-23

DAS
28
9-89

(1x)

DAS
46
9-89

MAR 03 2015

DAS
27
9-89

FEB 23 2015

DAS
28
9-89

(1x)

DAS
46
9-89

MAR 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 127706

127706

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Item ID: D206-781-151KIV Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Vertical Tunnel-Ivory
 Start Date: 12/12/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00				<u>IX</u>	<u>DAS</u> <u>28</u> <u>9-89</u>		<u>MAR 04 2015</u>
Packaging	Identify and pack for shipping as per PPP D206-781-151KIV Location: <u>EG302</u> PPP rev <u>PPP127824</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<u>MCS</u>	<u>15-03-05</u>		
Quality Control									<u>MF</u> <u>15-3-4</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 127706

127706

Parent Item: D206-781-151KIV

D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add ALS4-632-130 11/02/15 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4632-130		Purchased	No				Each	998.0000		8			
ALS4632-130 insert		DAS 46 9-89							**			DAS 27 FEB 23 2015	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST550				998					
					(118908)			998		8			
ALS4-632-80		Purchased	No				Each	64.0000		4			
ALS4-632-80 Insert		DAS 46 9-89							**			DAS 27 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		FEB 23 2015	
				ST550				64					
					(1130822)			64		4			
D3800-1-100		Manufactured	No				f	300.0000		14			
D3800-1-100 Hook And Loop Strip (1" Soft)		DAS 46 9-89							**			DAS 27 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		FEB 23 2015	
				ST419				300					
					(124095)			300		14			
D3800-3-100		Manufactured	No				f	75.0000		14			
D3800-3-100 Hook And Loop Strip (1" Hard)		DAS 46 9-89							**			DAS 27 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		FEB 23 2015	
				ST419				75					
					(124096)			75		14			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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Material									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 127706

Parent Item: D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

127706

D206-781-151KIV

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

D3822-1KIV Manufactured No

D3822-1KIV

Vertical Tunnel, LH-Ivory

D3822-2KIV Manufactured No

D3822-2KIV

Vertical Tunnel, RH-Ivory

D3822-3KIV Manufactured No

D3822-3KIV

Vertical Tunnel Aft Center

D3822-5KIV Manufactured No

D3822-5KIV

Vertical Tunnel, Top-Ivory

Each 0.0000

B12-7487 **

Each 0.0000

B12-7427 **

Each 0.0000

B12-7479 **

Each 1.0000

B12-7598 **

Location

ST427

95128

Loc Qty

1

1

Each 0.0000

B12-7504 **

Each 51.0000

**

Location

ST264

m127580

Loc Qty

51

51

Each 22.0000

**

Location

ST264

m130820

Loc Qty

22

22

Loc Code

m131340

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

FEB 23 2015

DAS

28

9-89

DAS

27

9-89

NAS388-6-8P

NAS388-6-8P

SCREW

Purchased No

DAS

46

9-89

Location

ST264

m130820

Loc Qty

22

22

Loc Code

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 127706

127706

Parent Item: D206-781-151KIV

D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

NAS391B6P

Purchased

No

Each

69.0000

**

18

DAS

27

FEB 23 2015

NAS391B6P

DAS

46

9-89

Washer

Location

Loc Qty

Loc Code

ST263

69

69

1430799

m131340

18

DAS
28
9-89

DAS

28

9-89

DQA: _____ Date: _____



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REFERENCE ONLY

DART AEROSPACE LTD.

MAR 03 2015

DAS
46
9-89

IIN-D407-781-3

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5.2 D206-781-141/-143/-151/-161/-171/-173/-191/-193 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Qty -191	Qty -193	Part Number	Description
X								D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X							D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		(X)						D206-781-151	VERTICAL TUNNEL KIT
			X					D206-781-161	REAR OVERHEAD KIT
				X				D206-781-171	HAT BIN KIT
					X			D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
						X		D206-781-191	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
							X	D206-781-193	ROTOR BRAKE PANEL KIT
1								D3821-1	PANEL - W/O ROTOR BRAKE
	1							D3821-3	PANEL - W/ ROTOR BRAKE
4	4							NAS388-6-8P	SCREW
4	4							NAS391B6P	WASHER
		(1)						D3822-1	VERTICAL TUNNEL, LH
		(1)						D3822-2	VERTICAL TUNNEL, RH
		(1)						D3822-3	VERTICAL TUNNEL, AFT CENTER
		(1)						D3822-5	VERTICAL TUNNEL, TOP
		(1)						D3822-7	VERTICAL TUNNEL, LOWER
		(2)						D3800-1-100-800	LOOP STRIP
		(2)						D3800-3-100-800	HOOK STRIP
		(4)						NAS388-6-8P	SCREW
		(14)						NAS388-6-12P	SCREW
		(18)						NAS391B6P	WASHER
		(4)						ALS4-632-80	INSERT
		(8)						ALS4-632-130	INSERT
			1					D3823-1	REAR OVERHEAD, LH
			1					D3823-2	REAR OVERHEAD, RH
			1					D3823-3	REAR OVERHEAD, CENTER
			10					AN525-10R24	SCREW
			10					NAS43DD3-68	SPACER
				1				D3824-1	HAT BIN
					1			D3824-3	HAT BIN
				6	6			D3851-1	DOUBLER
				4	4			AN525-10R10	SCREW
						1		D4077-1	OVERHEAD PANEL, LH
						1		D4077-2	OVERHEAD PANEL, RH
							1	D4118-1	ROTOR BRAKE PANEL
							1	D4119-1	PANEL
						6		NAS388-6-8P	SCREW
							4	NAS388-6-12P	SCREW
						6	4	NAS391B6P	WASHER
							4	MS21059L06	NUTPLATE
							8	MS20426AD3-3	RIVET

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